Advanced Metalworking with 3M support
Product symbols

- **SS** Stainless Steel
- **MS** Mild Steel
- **AL** Aluminium
- **AZ** Alumina Zirconia
- **AO** Aluminium Oxide
- **CU** 3M™ Cubitron™ Mineral
- **Sic** Silicon Carbide
- **QA** Grinding Aid
- **H** High Pressure
- **M** Medium Pressure
- **L** Low Pressure
- **TIG** TIG Weld
- **MIG** MIG Weld
- **H&S** Health and Safety Solution

3M Best Performer ✔ 3M’s recommendation for best performance under optimum conditions where value can be measured

Safety Icons

- Respiratory protection suggested
- Eye protection suggested
- Ear protection suggested
- Protective clothing suggested
- Extra level of eye protection suggested
Finishing and Surface Conditioning

Efficient, effective solutions for finishing:
- Matching and blending surface finishes
- Final blending
- Paint preparation

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<th>Products</th>
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Finishing and Surface Conditioning

**Straight grinder with pneumatic wheel**

- Portable flexible shaft machine offers versatility through a variety of detachable tool heads
- For graining and finishing a range of metal fabricated parts
- Ideal for large accessible areas
- Straight grinder has shaft to fit pneumatic wheel for use with belts, or direct fitting of Scotch-Brite™ Wheels

**Top tip**

Use Scotch-Brite™ Surface Conditioning Belt in ACRS grade as a final process step to produce a standard 3B finish on stainless steel.

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**3M™ Trizact™ CF Cloth Belt 337DC**

- Macro-replicated structured abrasive provides a consistent finish with exceptional life when compared to conventional abrasives
- Soft edge structure in conjunction with flexible backing provides good cut rate with blending capabilities

**Scotch-Brite Surface Conditioning Belt**

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non-woven web delivers excellent soft edge properties for the best blended finish

**Scotch-Brite Finishing Wheel**

- Convolutely wound construction provides a long product life with less conformability than a flap brush
- Range of grades available to achieve required finishes consistently throughout product life
- Remove small imperfections without dimensioning the part, meaning less re-work and a better quality finish first time

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Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

To find out more about our complete range of abrasive systems please call the **3M Customer Information Team**.

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5M Best Performer

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FS-WL 2SCRS 2SMED

150mm x 50mm x 25.4mm 30208 30209

FL-AC flange

25.4mm x 12.7mm 61327
File belt tool

- Lightweight, hand held tool with ergonomic offset design
- Increases capability to access hard-to-reach areas through a comprehensive range of contact arms
- Quick belt change feature

3M Trizact™
CF Cloth Belt 337DC

- Macro-replicated structured abrasive provides a consistent finish with exceptional life when compared to conventional abrasives
- Soft edge structure in conjunction with flexible backing provides good cut rate with blending capabilities
- A tougher alternative to conventional Trizact abrasives, for file belt applications

Scotch-Brite Surface
Conditioning Belt

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non-woven web delivers excellent soft edge properties for the best blended finish

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<th>3M 337DC</th>
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<tr>
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Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

0870 60 800 90 or visit www.3m.com/uk/abrasives
Roloc+ Flap Brush

- Each brush consists of flaps of Scotch-Brite material, designed to give a consistent finish throughout product life.
- Blends with soft edge action to match required finishes after a refining process.

Roloc+ Combi Flap Brush

- Alternate flaps of coated abrasive cloth and Scotch-Brite™ Web.
- More aggressive than a Scotch-Brite Flap Brush, for removing light scratches and re-graining.

Roloc+ Flap Brush (AO)

- Allows the use of 3M™ Roloc™ fixing mechanism to mount a range of 3M Roloc+ Quick Release Products without the use of tools/spanners.

Roloc+ Combi Flap Brush CB-ZR

- P80, P120, P180
- 63mm x 32mm
- No. 09717, 09720, 09723

Roloc+ Flap Brush FF-ZR

- FF-ZR AVFN, ACRS, AMED
- 75mm x 35mm
- No. 09706, 09703, 09702

Roloc+ Accessories

- Plastic holder with internal thread to matches Roloc+ spindle on brushes.
- Incorporates a 6mm shaft for easy mounting into die grinder collet.

Roloc+ Accessory Holder No. 1

- 6mm x 25mm
- No. 09884

Roloc+ Flap Brush (SiC) FF-ZR SFN

- 75mm x 35mm
- No. 09709

3M Best Performer

To find out more about our complete range of abrasive systems please call the 3M Customer Information Team.
3M™ Trizact™ CF Cloth Belt 337DC

- Macro-replicated structured abrasive provides a consistent finish with exceptional life when compared to conventional abrasives
- The soft edge structure and flexible backing of this product provide good cut rate with blending capabilities

3M Trizact Belt 237AA

- Micro-replicated structure of precisely positioned 3D pyramids of abrasive on the belt’s backing increases mineral and grinding aid content, resulting in consistent and predictable finishes, cooler cutting and extended belt life
- Designed for the polishing process where it facilitates a reduction in the number of steps required

Scotch-Brite Surface Conditioning Belts

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non-woven web delivers excellent soft edge properties for the best blended finish

Top tip
Use Scotch-Brite™ ‘film-backed’ belts for smooth running on the sander pad for flat surfaces; use Scotch-Brite ‘low-stretch’ belts where greater conformability is required.

Stroke sander Overhead belt machine

- For graining and finishing of most flat and box section parts
- Ideal for semi-automation of medium size production parts
- Opportunity to improve productivity and consistency of finish over a large area due to the fixed position of the belt

Finishing and Surface Conditioning

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

0870 60 800 90 or visit www.3m.com/uk/abrasives
Random orbital sander

- Orbital motion produces a random scratch pattern
- Use for paint preparation
- Idea for large accessible areas

Top tip
Always start the machine on the work surface and stop the machine off the work surface. This prevents unwanted deep scratch marks.

3M Hookit™ Disc 245
- Hookit fixing system means discs can be attached and reattached as many times as necessary
- Ideal choice for more demanding finishing applications due to heavy duty E-weight paper backing
- Open coat construction helps prevents premature loading and extends product life

3M Hookit Disc 255P
- Hookit fixing system means discs can be attached and reattached as many times as necessary
- High performance C-weight paper disc suited to lighter finishing applications
- Incorporates Fre-Cut™ Anti Loading coating to prevent clogging and extends product life refining process

3M Hookit Back Up Pad
- Rated to 12,000 rpm for use on the latest higher speed random orbital sanders
- Durable polyurethane construction for maximum life and good flexibility
- Well balanced for smooth running and reduced vibration

<table>
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<tr>
<th>3M Hookit Back Up Pad</th>
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</thead>
<tbody>
<tr>
<td>150mm x Plain</td>
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<tr>
<td>150mm x 6 hole</td>
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<td>150mm x 6 hole</td>
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<td>A00339</td>
<td>A00337</td>
</tr>
<tr>
<td>150mm x 6 hole</td>
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<td>A00327</td>
<td>A00325</td>
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</table>

To find out more about our complete range of abrasive systems please call the 3M Customer Information Team
Backstand machine Linisher

- For graining and finishing of most small fabricated parts
- Ideal for higher volume and complex parts where greater control is needed - part to belt.
- Increases capability to achieve desired finish through the choice of different contact wheel designs

3M™ Trizact™ CF Cloth Belt 337DC

- Macro-replicated structured abrasive provides a consistent finish with exceptional life when compared to conventional abrasives
- The soft edge structure and flexible backing of this product provides good cut rate with blending capabilities
- Robust structure enables use on medium / hard contact wheels - around 65 shore hardness

3M Trizact Belts 237AA

- Micro-replicated structure of precisely positioned 3D pyramids of abrasive on the belt’s backing increases mineral and grinding aid content, resulting in consistent and predictable finishes, cooler cutting and extended belt life
- Designed for the polishing process where it facilitates a reduction in the number of steps required.
- Due to the unique precision structure of the abrasive coating, optimised product performance is achieved on medium/soft contact wheels - around 45 shore hardness

Scotch-Brite™ Surface Conditioning Belt

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non woven web delivers excellent soft edge properties for the best blended finish on most contact wheels.
**Tube finisher (portable/planetary)**

- Choice of either a fixed planetary machine or hand held tube finisher, dependent on production volumes and type of component
- Can handle both bent and straight tubes
- Quickly and efficiently finishes tubing: handheld tools have good wrap-around, whilst planetary machines can achieve 100% coverage in one pass

### 3M™ Trizact™ CF Belt 337DC

- Macro-replicated structured abrasive provides a consistent finish with exceptional life when compared to conventional abrasives
- The soft edge structure and flexible backing of this product provides good cut rate with blending capabilities

### 3M Trizact™ Belt 237AA

- Micro-replicated structure of precisely positioned 3D pyramids of abrasive on the belt’s backing increases mineral and grinding aid content, resulting in consistent and predictable finishes, cooler cutting and extended belt life
- Designed for the polishing process where it facilitates a reduction in the number of steps required

### Scotch-Brite™ Surface Conditioning Belt

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non-woven web delivers excellent soft edge properties for the best blended finish on most contact wheels

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

To find out more about our complete range of abrasive systems please call the 3M Customer Information Team.
Spindle machine (bench/floor)

- For finishing and polishing most small fabricated parts
- Ideal for higher volume and complex parts where greater control is needed - part to abrasive
- Ability to mount large range of different rotary abrasives to achieve desired finish (e.g. wheels, brushes, mops)

Top tip
The Scotch-Brite™ 2S MED Finishing Wheel is the best option to match an existing 3B finish after the refining step.

Scotch-Brite™ Flap Brush

- Each brush is made up with flaps of Scotch-Brite material, designed to give a consistent finish throughout its long life
- Blends with soft edge action to match required finishes after a refining process

Scotch-Brite™ Lap Mop

- Designed to be mounted on tapered spindles
- High strength disc construction for maximum life and high conformance
- Use Medium grade for 3B type finishes or Very Fine grade for finer satin finishes

<table>
<thead>
<tr>
<th>Accessories</th>
<th>Flanges</th>
<th>Tapered Spindle Adaptor</th>
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<tbody>
<tr>
<td>25.4mm x 12.7mm width</td>
<td>61327</td>
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<tr>
<td>76.2mm x 12.7mm</td>
<td>A61311</td>
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<tr>
<td>76.2mm x 50mm width</td>
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Scotch-Brite™ Finishing Wheel

- Convolutely wound construction provides a long life product with less conformance than a flap brush
- Range of grades available to achieve required finishes consistently throughout product life
- Removes small imperfections without dimensioning the part, meaning less re-work and a better quality finish first time

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

0870 60 800 90 or visit www.3m.com/uk/abrasives
Match & finish system

- A single system for graining, blending and finishing, especially useful for stainless steel fabricators
- Ideal for flat, accessible areas
- Optimum finishing system for finishing stainless steel due to its convenience, flexibility and portability

Top tip
The Scotch-Brite™ CS-MB or SC-BF ACRS products are the best options to match an existing 3B finish after the refining step. Finish can be softened by using them in conjunction with 3M Stainless Steel Cleaner.

Scotch-Brite™ Surface Conditioning Belts

- A tough, non-woven nylon web impregnated with mineral throughout its structure, provides a uniform consistent finish
- Produces a smooth, burr-free surface ideal for pharmaceutical and catering equipment fabrications
- Spring-like action of the non woven web delivers excellent soft edge properties for the best blended finish

Scotch-Brite Mini Flap Brush

- Each brush is made up with flaps of Scotch-Brite material, designed to give a consistent finish throughout its long life
- Blends with soft edge action to match required finishes after refining process
- Supplied with 4 keyway 19mm bore design to fit all machines in this category

Accessory – pneumatic wheel

- Inflates to desired firmness to optimise finish and minimise chatter
- Provided with valve suitable for most inflation devices for easy replacement of belts
- Light weight, well balanced design to minimise vibration

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<tr>
<th>Accessory - Pneumatic Wheel</th>
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<td>90mm x 100mm x 19mm</td>
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Please see our ‘Optimum Process Guides’ section for tips on an easy 3-step match and finish operation.

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

3M Best Performer

To find out more about our complete range of abrasive systems please call the 3M Customer Information Team
By hand

- Final blending by hand allows the operator to correct any areas of mismatch, putting the final touch to a job
- Use of the 3M Handpad Holder evens out the pressure applied resulting in a uniform finish

Scotch-Brite™ Handpads

- Non-woven nylon web impregnated with mineral throughout its structure provides a uniform, consistent, burr-free finish
- Excellent material flexibility for finishing in all areas

Scotch-Brite Pre-Cut Purple Handpads

- An improved line of Scotch-Brite handpads offering longer life, higher cut and a more consistent finish over standard pads
- The cost effective ‘hand sized’ pads (designed to fit the 3M Handpad Holder) are supplied in pre-cut sheets on a roll for ease of use and to reduce product wastage

Accessories

- 3M recommends using the 3M Handpad Holder with Scotch-Brite Handpads for surface blending
- 3M Stainless Steel Cleaner, used in conjunction with a Scotch-Brite Handpad, helps to produce a matt finish (lower reflectivity) and provides protection against handling marks

<table>
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<th>Accessories</th>
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<td>3M Stainless Steel Cleaner</td>
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<td>600g Aerosol Can</td>
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<td>AVFN</td>
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0870 60 800 90 or visit www.3m.com/uk/abrasives

7446 SCRS
155mm x 225mm 04051

7447 AVFN
155mm x 225mm 05303

7446 SCRS
115mm x 150mm 04051